

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018017**Date Inspected:** 02-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	An Qing Xing	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG COMPONENT	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Outside Yard

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG segment 11BE to 11CE, weld No.SP715-001-035.The welder is identified as #047353. ZPMC QC is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

SMAW in the 3G position for the OBG segment 11BE to 11CE, weld No.DP706-001-021.The welder is identified as #500363. ZPMC QC is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-T-3213-B-U3b.

SMAW in the 4G position for the OBG segment 11BE to 11CE, weld No.EP171-001-014.The welder is identified as #044515. ZPMC QC is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

FCAW in the 2G position for the OBG crossbeam CB17, weld No.CB3001A-017-005.The welder is identified as #066421. ZPMC QC is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appear to comply

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## WELDING INSPECTION REPORT

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with WPS-B-T-2232-Tc-U4b-F.

Bay#9

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG service platform, MT repair weld No.SP4-B-1-002. The welder is identified as #059464. ZPMC QC is identified as Mr. Chen Shi Gang. The welding variables recorded by QC appear to comply with WPS-345-FCAW-3G (3F)-REPAIR-1. The weld repair report is identified as CWR2136.

Ultrasonic Testing (A,B,C and D-Scan )

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as butt joint joining between bottom Plate to side Plate for OBG segment 11AE at bike path side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of "D" Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

SEG066A-012

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as butt joint joining between bottom Plate to side Plate for OBG segment 11BE at bike path side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of "D" Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

SEG068A-043

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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ZPMC performing Carbon Arc Back Gouging for splice joint joining between Side plate to Side plate at bikepath side on Segment 11BE to 11CE



ZPMC personnel performing FCAW repair weld joint SP4-B-1-002 at 3G position on OBG service platform at Bay#9



### Summary of Conversations:

No relevant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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